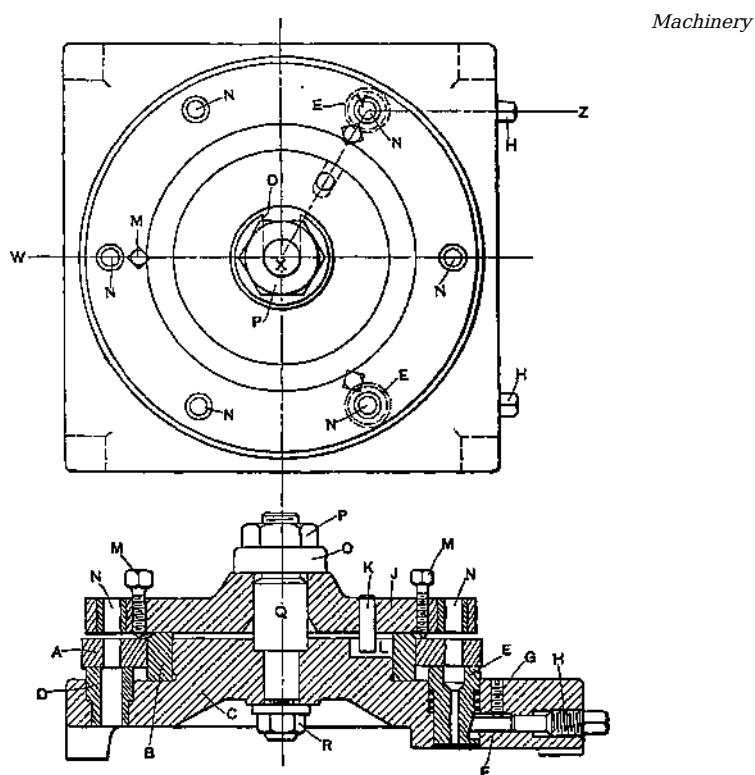


The steel liner bushings *F* are provided in the body of the casting so that the main bushings, which are of the removable *type* as shown at *H*, may not produce too much wear in the jig body itself. A slot is provided in the head of the bushing so that the pin *K* will prevent it from turning under the twist-

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**Fig. 2. Drill Jig for Rough Steel Collar**

ing action of the drill. It should be noted that in the construction of the spring-pins which are used to help support the casting, the springs themselves should be very light so that they will not force the piston out of its true position, determined by the locating stud.

**DriH Jig for a Rough Collar.** — The steel adjusting collar *A* which is shown in Fig. 2 has been previously

bored, but no